

Kaymar

Fitting Instructions

Tightening Torque Values

Metric Hexagon Bolts & Screws, Coarse Pitch Threads.
Property classes 4.6, 5.8 & 8.8

		Prop Class 4.6		Prop Class 5.8		Prop class 8.8	
		Bolt Tension kN	Torque Nm	Bolt Tension kN	Torque Nm	Bolt Tension kN	Torque Nm
M1.6	0.35	0.19	0.06	0.31	0.10	0.48	0.15
M2	0.40	0.31	0.12	0.51	0.20	0.78	0.31
M2.5	0.45	0.50	0.25	0.84	0.42	1.28	0.64
M3	0.50	0.73	0.44	1.24	0.74	1.90	1.10
M4	0.70	1.29	1.00	2.17	1.70	3.32	2.70
M5	0.80	2.08	2.10	3.51	3.50	5.35	5.00
M6	1.00	2.94	3.50	4.97	5.90	7.54	9.00
M8	1.25	5.36	8.50	9.04	14.00	13.80	22.00
M10	1.50	8.45	17.00	14.30	29.00	21.90	44.00
M12	1.75	12.40	30.00	20.80	49.00	31.80	77.00
M14	2.00	16.80	47.00	28.40	79.00	43.40	122.00
M16	2.00	22.90	73.00	38.80	124.00	59.20	190.00
M18	2.50	28.10	101.00	47.50	171.00	74.80	269.00
M20	2.50	35.80	143.00	60.50	242.00	95.60	372.00
M22	2.50	44.30	195.00	74.80	329.00	118.00	519.00
M24	3.00	51.60	248.00	87.10	418.00	138.00	640.00
M27	3.00	66.90	361.00	113.00	610.00	179.00	967.00
M30	3.50	81.90	491.00	138.00	828.00	219.00	1314.00
M33	3.50	101.00	667.00	172.00	1135.00	270.00	1782.00
M36	4.00	120.00	864.00	202.00	1454.00	319.00	2297.00
M42	4.50	164.00	1378.00	277.00	2327.00	437.00	3671.00
M48	5.00	215.00	2064.00	363.00	3485.00	573.00	5500.00
M56	5.50	298.00	3338.00	501.00	5611.00	792.00	8870.00
M64	6.00	393.00	5030.00	662.00	8473.00	1045.00	13376.00

Note: bolt tensions detailed in above table equate to 65% of proof load.

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Fitting Instructions

Metric Hexagon Bolts, Fine Pitch Threads
Property class 12.9
Threads to ISO 898/1

Property Class			12.9	
Diam	Pitch mm	TSA Mm2	kN Bolt Tension	Torque Nm
8	1.00	39.20	24.70	40.00
10	1.25	61.20	38.60	77.00
12	1.25	92.10	58.00	139.00
14	1.50	125.00	78.70	220.00
16	1.50	167.00	105.00	336.00
18	1.50	216.00	137.00	493.00
20	1.50	272.00	172.00	688.00
22	1.50	333.00	210.00	924.00
24	2.00	384.00	242.00	1162.00
27	2.00	496.00	313.00	1690.00
30	2.00	621.00	391.00	2346.00
33	2.00	761.00	480.00	3168.00
36	3.00	865.00	545.00	3924.00

Note: bolt tensions detailed in above table equate to 65% of proof load.